



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW1805G01731-3G

Job Sheet 190574



Part No: RBW1805G01731-3G

Job Qty: 2 pcs

Part Name: Mast Vibration Absorber Removal Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/11/19

Job Tracking No: SIOP

Due Date: 3/12/19

Created By: Dara Macdonald

Type: Stock

Description:

Note: DWG RBW1805G01731-3G REV 3 IPP REV A 18.02.16 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	2 pcs	3/12/19		0.00	2.00	Small Fab - 1		MLC
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	2 pcs	3/12/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
130	Packaging 3-1 - Stock - B4B	2 pcs	3/12/19		0.00	0.00	Packaging 3 - 1 - B4B		DAS 40 9-89
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		



Container No: S155043



Part: RBW1805G01731-3G

Job No: 190574

Serial No/Batch: S155043

Revision: 3

Inspector:

Exp Date:

Instructions:

Date: 02/20/19

DART Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - FG	2 pcs	3/12/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
					QC 21 - SA - 53

DAS
21
0-25

MAR 06 2019

Part Op **100** - (Small Fab) 1- Assemble as per DWG RBW1805G01731-3G
 Descriptions: **110** - (QC5- Inspect part completeness to step on W/O)
130 - (Identify as per dwg & Stock Location: _____)
140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
91590A117	External Snap Ring .375	20 Ea (10 ea)	100-Small Fab - 1	5048567
94355A227	18-8 Stainless Steel Flat-Tip Set Screws, 10-24 Thread, 1/2" Long	20 Ea (10 ea)	100-Small Fab - 1	5093312
RBW1805G01731-3G-1 Top Plate		2 pcs (1 ea)	100-Small Fab - 1	5108378
RBW1805G01731-3G-3 Jack Plate		2 pcs (1 ea)	100-Small Fab - 1	516489
RBW1805G01731-3G-5 Button		16 pcs (8 ea)	100-Small Fab - 1	5119337
RBW1805G01731-3G-7 Jacking Screw		16 pcs (8 ea)	100-Small Fab - 1	5116942
RBW1805G01731-3G-9 Pull Screw		20 pcs (10 ea)	100-Small Fab - 1	5065330

Job Allocations

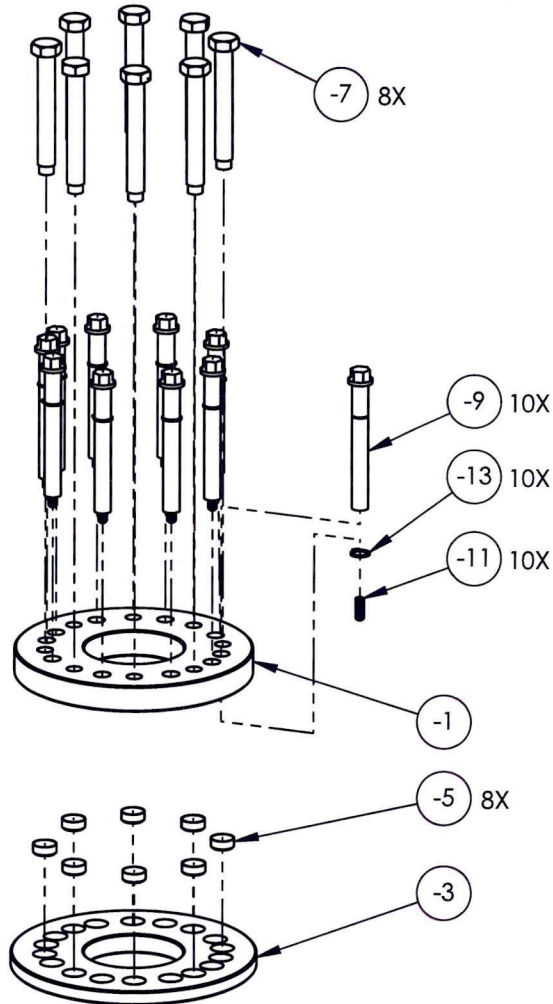
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	91590A117	20	148	0
	94355A227	20	80	0
	RBW1805G01731-3G-1	2	6	0
	RBW1805G01731-3G-3	2	7	0
	RBW1805G01731-3G-5	16	72	0
	RBW1805G01731-3G-7	16	88	0
	RBW1805G01731-3G-9	20	10	0

Part Specifications

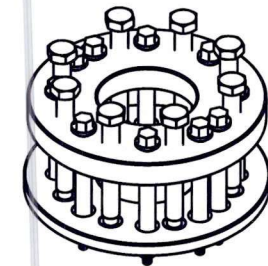
Specifications could not be found.

Plex 2/11/19 1:06 PM Dart.Macdonald.Dara

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	15-0288	ADDED NOTE 3 SHT 1, ADDED VIEW TO SHOW DIM OF ASSEMBLED -11 INTO -9. -1 CH'D DIM WAS Ø.355 THRU IS Ø.3564-.3555 THRU. -5 CH'D MATERIAL CALLOUT WAS 4140 IS 4140/4142. -9 CH'D DIM'S WAS 10-24 UNC X .125 IS 10-24 UNC X .25, WAS Ø.355 IS Ø.3550-.3544. -11 CH'D WAS #10-24 X 3/8 IS #10-24 UNC X 1/2.	9/2/2015	RJC	JAG
3	17-0143	-1 CH'D DIM'S WAS 10X Ø.3564/.3555 THRU IS 10X Ø.359/.357 THRU ALL, WAS 1.800 IS 2X 1.800, WAS 1.355 IS 2X 1.355, WAS .875 IS 2X .875, WAS .282 IS 2X .282, WAS .875 IS 2X .875, WAS 1.355 IS 2X 1.355, WAS 1.800 IS 2X 1.800, WAS 1.908 IS 2X 1.908, WAS 1.719 IS 2X 1.719, WAS 1.373 IS 2X 1.373, WAS .695 IS 2X .695, WAS .695 IS 2X .695, WAS 1.373 IS 2X 1.373, WAS 1.719 IS 2X 1.719, WAS 1.908 IS 2X 1.908, CH'D ENGRAVE NOTE WAS ENGRAVE P/N: "RBW1805G03351-3G" IS ENGRAVE P/N. -3 CH'D DIM'S WAS 8X Ø.192 THRU ALL L J Ø.500 X .210 IS 8X Ø.192 THRU ALL L J Ø.5007/.5000 X .210 (P.F.-5), WAS 1.800 IS 2X 1.800, WAS 1.355 IS 2X 1.355, WAS .875 IS 2X .875, WAS .282 IS 2X .282, WAS .282 IS 2X .282, WAS .875 IS 2X .875, WAS 1.355 IS 2X 1.355, WAS 1.800 IS 2X 1.800, WAS 1.908 IS 2X 1.908, WAS 1.719 IS 2X 1.719, WAS 1.373 IS 2X 1.373, WAS .695 IS 2X .695, WAS .695 IS 2X .695, WAS 1.373 IS 2X 1.373, WAS 1.719 IS 2X 1.719, WAS 1.908 IS 2X 1.908, CH'D ENGRAVE NOTE WAS ENGRAVE P/N: "RBE1805G03031-3G" IS ENGRAVE P/N. -5 CH'D DIMS WAS Ø.500 IS Ø.5016/.5012 (P.F.-3), WAS R1.00 IS SR1.00. ADDED DIM .03 X 45°. -7 DELETED DIMS 2.75, .200. ADDED DIMS 2.76, .213, SR 1.00. -9 CH'D DIM WAS .375 IS 3X .375/.362, WAS Ø.3550/.3544 IS .355/.353, WAS (.750) IS .75.	6/19/2017	RJC	JAG



NOTE:

1. REF. AUGUSTA T/N: 3G1805G01731.
2. ALSO PART OF KIT RBW1805G01431-3G, REF. AUGUSTA T/N: 3G1805G01431.

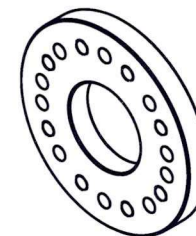
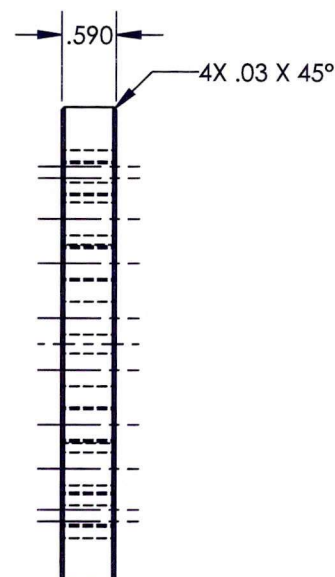
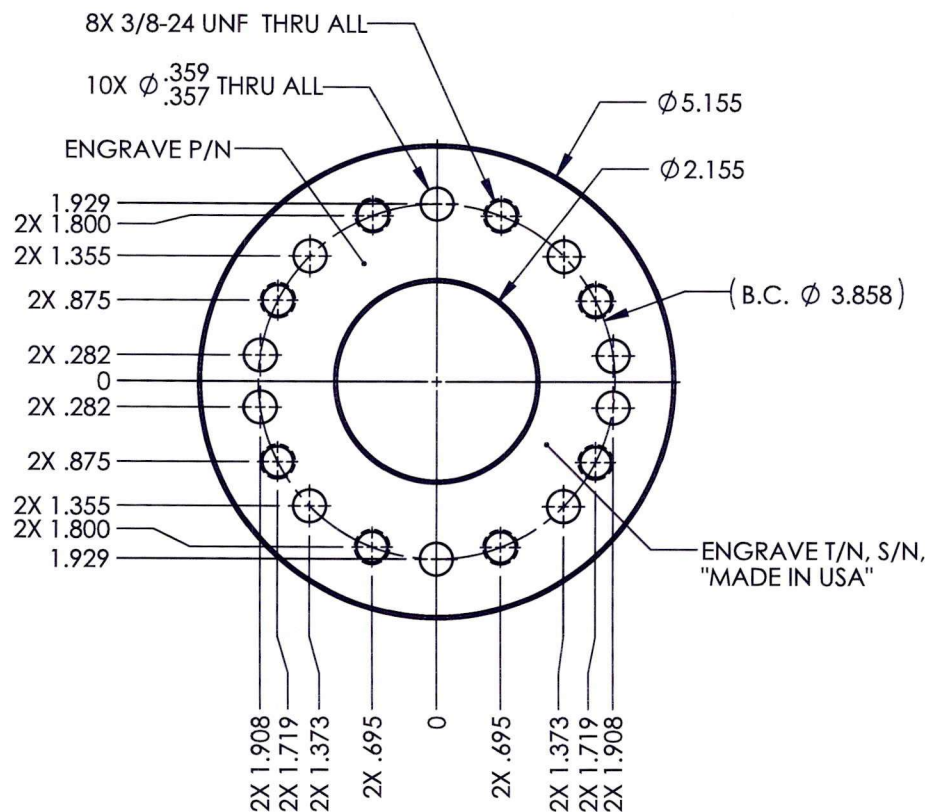
3 USE PERMANENT LOCTITE.

DART AEROSPACE																	
TITLE MVA REMOVAL TOOL																	
DWG NO. RBW1805G01731-3G	REV 3																
<table border="1"> <tr> <td>MAT'L HEAT TREAT FINISH</td> <td>UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES XXX ± .005 FRACTIONS ± 1/8 XX ± .01 ANGLES ± 5° X ± .1 SURFACES = 125/✓</td> </tr> <tr> <td>SPEC</td> <td>1. BREAK ALL SHARP EDGES .015 x 45° OR .015R</td> </tr> <tr> <td>DRAWN BY: SMITH</td> <td>2. DIMENSIONAL LIMITS APPLY AFTER PLATING</td> </tr> <tr> <td>CHECKED: DD 06/22/2017</td> <td>3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009</td> </tr> <tr> <td>OPPS APPR: AA 06/26/2017</td> <td>USED ON MODEL</td> </tr> <tr> <td>QA APPR: JL 06/28/2017</td> <td>AW139</td> </tr> <tr> <td>APPROVED: JAG 07/03/2017</td> <td></td> </tr> <tr> <td>SCALE 1:4</td> <td>DATE 4/25/2013 SHEET 1 OF 6</td> </tr> </table>		MAT'L HEAT TREAT FINISH	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES XXX ± .005 FRACTIONS ± 1/8 XX ± .01 ANGLES ± 5° X ± .1 SURFACES = 125/✓	SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	DRAWN BY: SMITH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING	CHECKED: DD 06/22/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	OPPS APPR: AA 06/26/2017	USED ON MODEL	QA APPR: JL 06/28/2017	AW139	APPROVED: JAG 07/03/2017		SCALE 1:4	DATE 4/25/2013 SHEET 1 OF 6
MAT'L HEAT TREAT FINISH	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES XXX ± .005 FRACTIONS ± 1/8 XX ± .01 ANGLES ± 5° X ± .1 SURFACES = 125/✓																
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R																
DRAWN BY: SMITH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING																
CHECKED: DD 06/22/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009																
OPPS APPR: AA 06/26/2017	USED ON MODEL																
QA APPR: JL 06/28/2017	AW139																
APPROVED: JAG 07/03/2017																	
SCALE 1:4	DATE 4/25/2013 SHEET 1 OF 6																

ASSY QTY	ASSY QTY	B/O	Part #	QTY.	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	TOP PLATE	S.S.		2
			-3	1	JACK PLATE	S.S.		3
			-5	8	BUTTON	4140/4142		4
			-7	8	JACKING SCREW	S.S.	3/8-24 X 3 (MCMASTER-CARR #93190A373) MODIFIED	5
			-9	10	PULL SCREW	S.S.		6
		B/O	-11	10	SET SCREW	S.S.	10-24 UNC X 1/2 (MCMASTER-CARR #94355A227)	1
		B/O	-13	10	RETAINING RING	S.S.	Ø3/8 (MCMASTER-CARR #91590A117)	1

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	15-0288	-1 CH'D DIM WAS Ø.355 THRU IS Ø.3564-.3555 THRU.	9/2/2015	RJC	JAG
3	17-0143	-1 CH'D DIM'S WAS 10X Ø.3564/.3555 THRU IS 10X Ø.359/.357 THRU ALL, WAS 1.800 IS 2X 1.800, WAS 1.355 IS 2X 1.355, WAS .875 IS 2X .875, WAS .282 IS 2X .282, WAS .282 IS 2X .282, WAS .875 IS 2X .875, WAS 1.355 IS 2X 1.355, WAS 1.800 IS 2X 1.800, WAS 1.908 IS 2X 1.908, WAS 1.719 IS 2X 1.719, WAS 1.373 IS 2X 1.373, WAS .695 IS 2X .695, WAS .695 IS 2X .695, WAS 1.373 IS 2X 1.373, WAS 1.719 IS 2X 1.719, WAS 1.908 IS 2X 1.908. CH'D ENGRAVE NOTE WAS ENGRAVE P/N: "RBW1805G03351-3G" IS ENGRAVE P/N.	6/19/2017	RJC	JAG

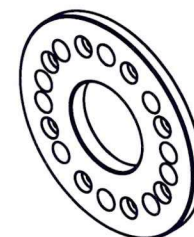
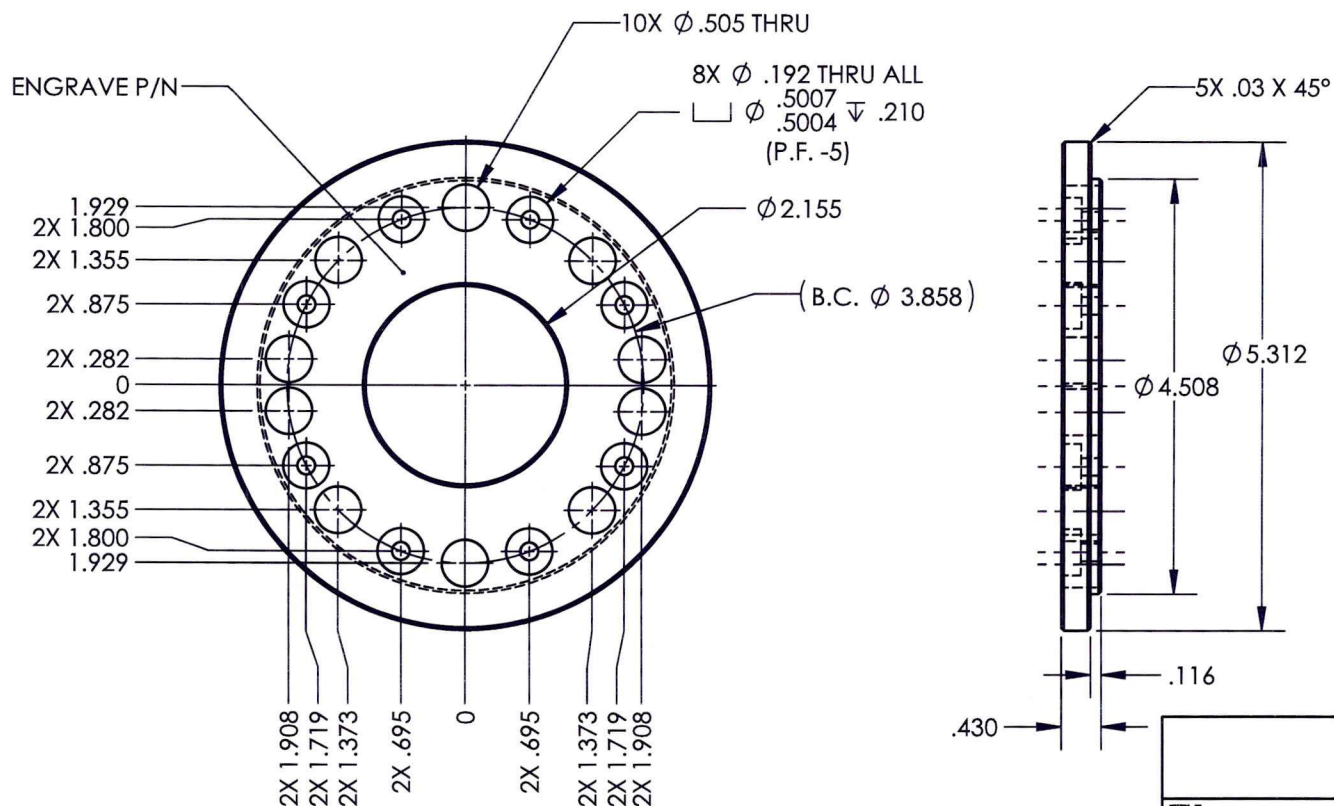


①
TOP PLATE

DART AEROSPACE	
TITLE MVA REMOVAL TOOL	
DWG NO. RBW1805G01731-3G-1	REV 3
MAT'L S.S.	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH	.XX ± .01 ANGLES ± 5°
SPEC	.X ± .1 SURFACES = 125/✓
DRAWN BY: RJC 06/19/2017	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DD 06/22/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 06/26/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 06/28/2017	USED ON MODEL
APPROVED: JAG 07/03/2017	AW139
SCALE 1:2	DATE 6/19/2017
SHEET 2 OF 6	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3	17-0143	-3 CH'D DIM'S WAS 8X ϕ .192 THRU ALL $\square$ ϕ .500 ∇ .210 IS 8X ϕ .192 THRU ALL $\square$ ϕ .5007/.5000 ∇ .210 (P.F.-5), WAS 1.800 IS 2X 1.800, WAS 1.355 IS 2X 1.355, WAS .875 IS 2X .875, WAS .282 IS 2X .282, WAS .282 IS 2X .282, WAS .875 IS 2X .875, WAS 1.355 IS 2X 1.355, WAS 1.800 IS 2X 1.800, WAS 1.908 IS 2X 1.908, WAS 1.719 IS 2X 1.719, WAS 1.373 IS 2X 1.373, WAS .695 IS 2X .695, WAS .695 IS 2X .695, WAS 1.373 IS 2X 1.373, WAS 1.719 IS 2X 1.719, WAS 1.908 IS 2X 1.908. CH'D ENGRAVE NOTE WAS ENGRAVE P/N: :RBW1805G03031-3G" IS ENGRAVE P/N.	6/19/2017	RJC	JAG



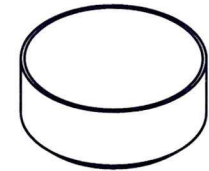
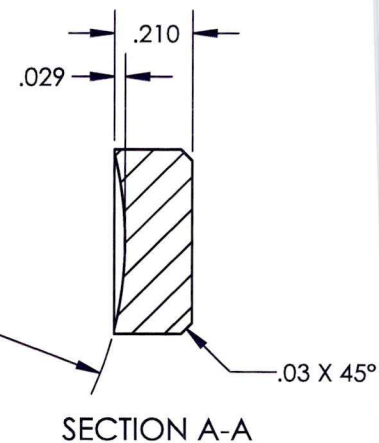
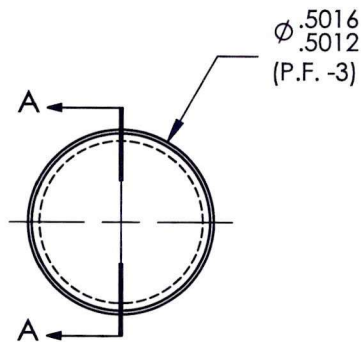
(-3)

JACK PLATE

DART AEROSPACE	
TITLE MVA REMOVAL TOOL	
DWG NO. RBW1805G01731-3G-3	REV 3
MAT'L S.S.	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX $\pm$.005 FRACTIONS $\pm$ 1/8
FINISH	.XX $\pm$.01 ANGLES $\pm$ 5°
SPEC	.X $\pm$.1 SURFACES = 125/
DRAWN BY: RJC 06/19/2017	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DD 06/22/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 06/26/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 06/28/2017	USED ON MODEL
APPROVED: JAG 07/03/2017	AW139
SCALE 1:2	DATE 6/19/2017
SHEET 3 OF 6	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	15-0288	-5 CH'D MATERIAL CALLOUT WAS 4140 IS 4140/4142.	9/2/2015	RJC	JAG
3	17-0143	-5 CH'D DIMS WAS Ø.500 IS Ø.5016/.5012 (P.F. -3), WAS R1.00 IS SR1.00. ADDED DIM .03 X 45°.	6/19/2017	RJC	JAG

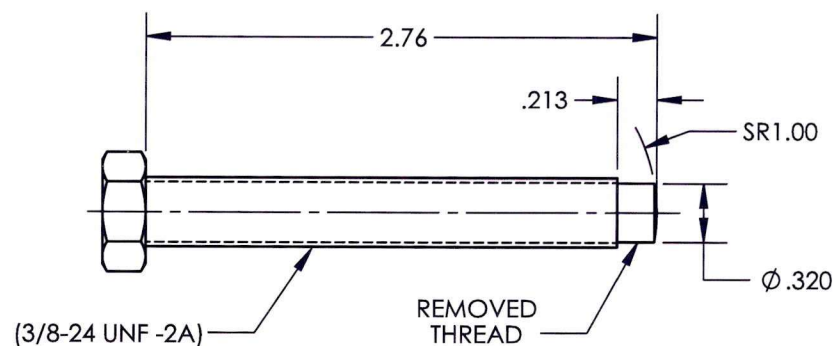
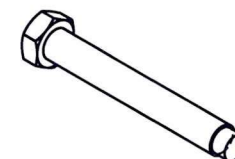


(-5)
BUTTON

DART AEROSPACE	
TITLE MVA REMOVAL TOOL	
DWG NO. RBW1805G01731-3G-5	REV 3
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT HRC 50-55	.XXX ± .005 FRACTIONS ± 1/8
FINISH BLACK OXIDE	.XX ± .01 ANGLES ± 5°
SPEC QMSI-6.2.2, B.O. REV D	X ± .1 SURFACES = 125/✓
DRAWN BY: RJC 06/19/2017	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DD 06/22/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 06/26/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 06/28/2017	USED ON MODEL
APPROVED: JAG 07/03/2017	AW139
SCALE 2:1	DATE 6/19/2017 SHEET 4 OF 6

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3	17-0143	-7 DELETED DIMS 2.75, .200. ADDED DIM'S 2.76, .213, SR 1.00.	6/19/2017	RJC	JAG



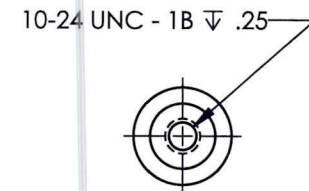
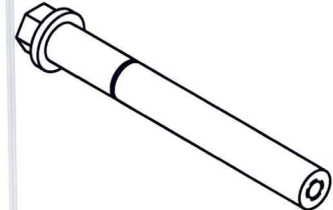
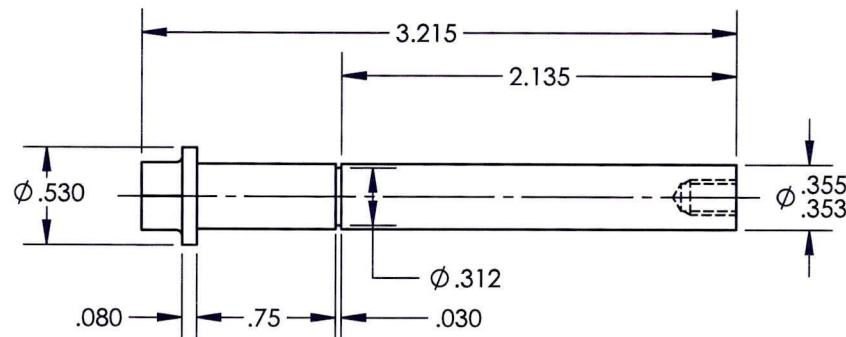
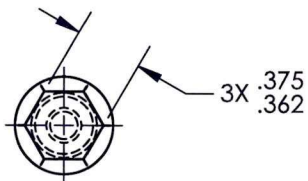
(-7)

JACKING SCREW

DART AEROSPACE	
TITLE MVA REMOVAL TOOL	
DWG NO. RBW1805G01731-3G-7	REV 3
MAT'L S.S.	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH	.XX ± .01 ANGLES ± 5°
SPEC	X ± .1 SURFACES = 125/
DRAWN BY: RJC 06/19/2017	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DD 06/22/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 06/26/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 06/28/2017	USED ON MODEL
APPROVED: JAG 07/03/2017	AW139
SCALE 1:1	DATE 6/19/2017
SHEET 5 OF 6	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	15-0288	-9 CH'D DIM'S WAS 10-24 UNC ∇ .125 IS 10-24 UNC ∇ .25, WAS $\varnothing$.355 IS $\varnothing$.3550-.3544.	9/2/2015	RJC	JAG
3	17-0143	-9 CH'D DIM WAS .375 IS 3X .375/.362, WAS $\varnothing$.3550/.3544 IS .355/.353, WAS (.750) IS .75.	6/19/2017	RJC	JAG



(-9)

PULL SCREW

DART AEROSPACE	
TITLE MVA REMOVAL TOOL	
DWG NO. RBW1805G01731-3G-9	REV 3
MAT'L S.S.	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT	.XXX $\pm$.005 FRACTIONS $\pm$ 1/8
TREAT	.XX $\pm$.01 ANGLES $\pm$ 5°
FINISH	.X $\pm$.1 SURFACES = 125/✓
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: RJC 06/19/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: DD 06/22/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: AA 06/26/2017	USED ON MODEL
QA APPR: JL 06/28/2017	AW139
APPROVED: JAG 07/03/2017	
SCALE 1:1	DATE 6/19/2017 SHEET 6 OF 6

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					